

mid

Order 11943



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Canada

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D4150-041

Job Sheet 188911



067795

Part No: D4150-041

Job Qty: 4 pcs

Part Name: Attachment Arm Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 10.06.24 new issue DD ver:EC IPP Rev:B 10.07.22 as per revB DD ver:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	2/12/19		0.00	0.11	Small Fab - 1		DAS 58 -89 Sign-off JAN 29 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	2/12/19		0.00	0.00	QC 5 - 10		DAS 38 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Packaging 3-1 - Stock - B4B	4 pcs	2/12/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

PTO
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					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	5-081
					Packaging 3 - 28 - B4B	5-081
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
130 QC 21 - SA	4 pcs	2/12/19	0.00 0.00	QC 21 - SA - 21	DA	
				QC 21 - SA - 70	21	

Part Op 100 - (Small Fab)

Descriptions: 110 - QC5- Inspect part completeness to step on W/O)

120 - (Identify as per dwg & Stock Location:_____)

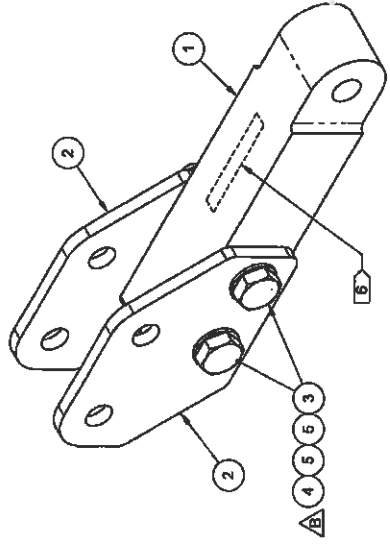
130 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
AN3C13A	Bolt	8 Ea (2 ea)	100-Small Fab - 1	5134217
D4150-1	Arm	4 pcs (1 ea)	100-Small Fab - 1	5145816
D4150-3	Arm Plate	8 pcs (2 ea)	100-Small Fab - 1	5133688
MS21043-3	Nut	8 Ea (2 ea)	100-Small Fab - 1	5143711
NAS1149C0332R	Washer	16 Ea (4 ea)	100-Small Fab - 1	5101354

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	AN3C13A	8	101	0
	D4150-1	4	5	0
	D4150-3	8	20	0
	MS21043-3	8	805	0
	NAS1149C0332R	16	3,751	0

Part Specifications

Specifications could not be found.

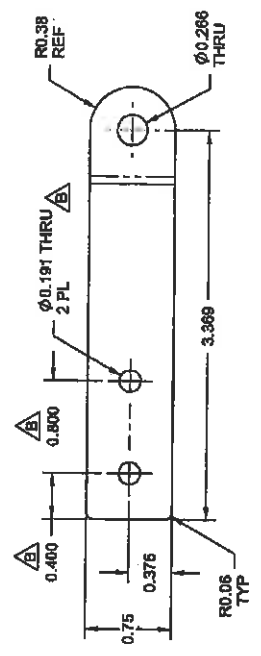
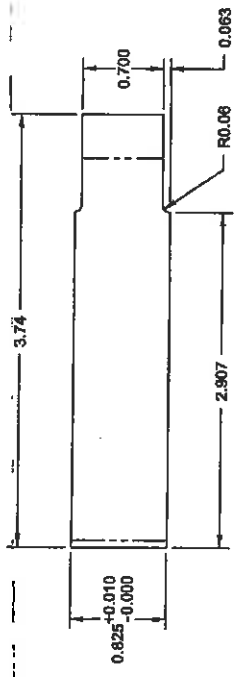
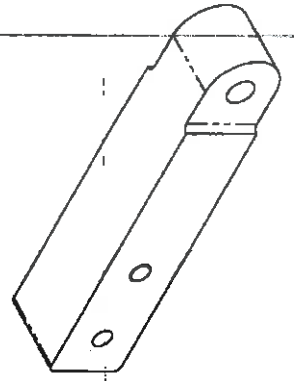


D4150-041 ATTACHMENT ARM ASSY

RELEASED
R 2010-07-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.82 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	10.06.18
B	REPLACED QTY(3) MS20515-4M20 WITH QTY(2) EACH AN5013A MS21043-3 AND QTY(1) NAS1148C032R. REASON: SEE TR-0350-007-2 REV. B.	MB	10.07.08
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DESIGN	DRAWING NO.	REV. B	
CHECKED	D4150	SHEET 1 OF 3	
MFG. APPR.	TITLE	SCALE	
DE APPR.	ATTACHMENT ARM ASSY	NTS	
DATE	10.07.08		



D4150-1 ARM

RELEASED
R 2010-07-16
14P

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A562 OR ASTM A276
REF DART SPEC M304B OR M309B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAYNESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	10.07.08		



NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,
PER MIL-S-5598 OR AISI 5613/6524 OR ASTM A240 OR ASME SA240
REF PART SPEC M304S11GA OR M303S11GA

- REF PART SPEC M304S11GA OR M203S11GA
- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.10 lbs

[illegible]

Entered: _____ Date: _____

NCR No. 19-7358

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: 188911
Part No. D450-041

DISPOSITION

Rework ☒
Scrap ☐
Use-as-is ☐

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☒

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: JAN 29 2019

Sequence #: 100 SMALL FAB - 1

QTY Affected: 4 PCS

MRB (QS1042) 190725

Description Work Order Deviation

Disposition

missing AN3C13A X2
NAS11490332R X2

-GET PARTS FROM STORE TO COMPLETE PIC.

Completed By DAS 68
JAN 29 2019

Lead hand / Supervisor 19/01/2019

QC / QA Coordinator DAS 68

JAN 29 2019

Root Cause

Operator ☒
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: _____

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☒
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐